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RB T103347-101
Job Sheet 201529



Part No: RB T103347-101

Job Qty: 1 pcs

Part Name: Cyclic Stick Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/7/19

Job Tracking No:

Due Date: 10/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB T103347-101 Rev 2 IPP Rev. A 19.05.06 New issue DP Verify DD

Ship Via:

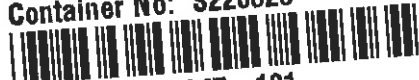
Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	10/15/19		0.25	0.50	Small Fab - 1		M.L.
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
110	QC 5	1 pcs	10/15/19		0.00	0.00	QC 5 - 10		DAS 81 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	10/15/19		0.00	0.00	Packaging 3 - 1 - B4B		OCT 07 2019
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		



Container No: S220328



Part: RB T103347 - 101

Job No: 201529

Serial No/Batch: S220328

Revision: 2

Inspector:

Exp Date:

Instructions:

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Date: 10/07/19

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				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	1 pcs	10/15/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

DAS
78
9-89

10/7/
2019

DAS
21
9-89

OCT 07 2019

Part Op 100 - (Small Fab) Assemble as per drawing.
 Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
23-006C00-22-16	Bushing	1 Ea (1 ea)	100-Small Fab - 1	5181202
23-006C16-22-16	Bushing	2 Ea (2 ea)	100-Small Fab - 1	5211656A
AN122721	Pin	1 Ea (1 ea)	100-Small Fab - 1	5183561
AN44-6	Bolt	1 Ea (1 ea)	100-Small Fab - 1	5183241
MS16555-641	Pin	2 Ea (2 ea)	100-Small Fab - 1	5202536
MS20074-04-06	Bolt	3 Ea (3 ea)	100-Small Fab - 1	5183245
MS21042L5	Nut	1 Ea (1 ea)	100-Small Fab - 1	5208332
MS35426-29	Wing Nut	1 Ea (1 ea)	100-Small Fab - 1	5184791
NAS1149D0463K	Flat Washer	3 Ea (3 ea)	100-Small Fab - 1	5183307
NAS1149D0563J	Washer	1 Ea (1 ea)	100-Small Fab - 1	5174282
NAS6605-22	Bolt	1 Ea (1 ea)	100-Small Fab - 1	5183283
RB T103347-101-103	Support Assembly	1 pcs (1 ea)	100-Small Fab - 1	5192762
RB T103347-101-115	Base	1 pcs (1 ea)	100-Small Fab - 1	5200819
RB T103347-101-117	Clamp	1 pcs (1 ea)	100-Small Fab - 1	5186350

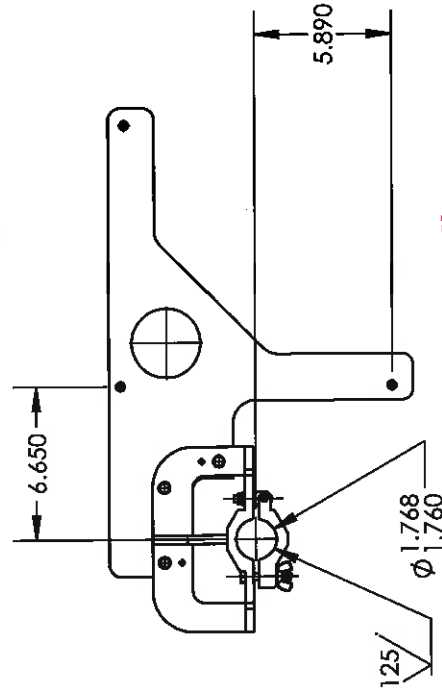
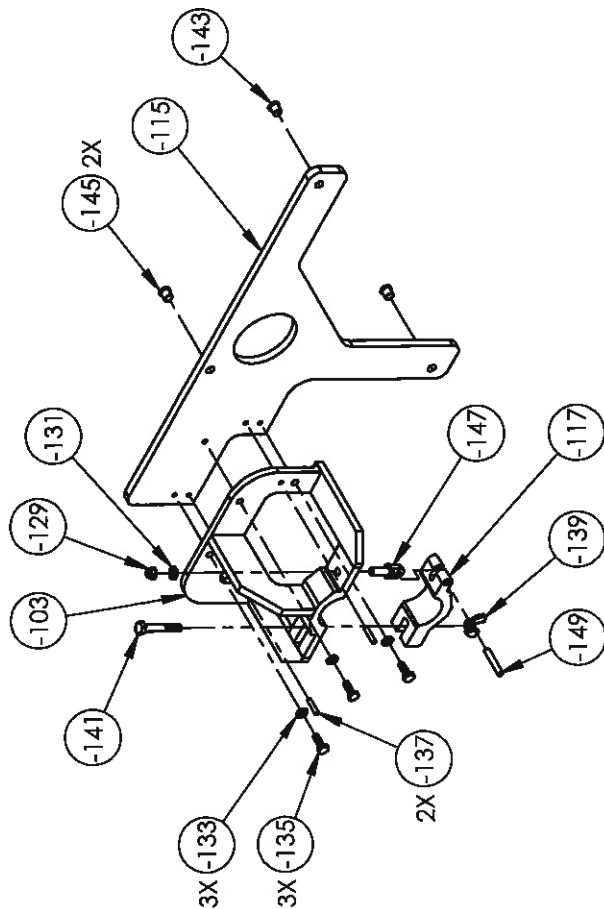
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	23-006C00-22-16	1	8	0
	23-006C16-22-16	2	16	0
	AN122721	1	6	0
	AN44-6	1	6	0
	MS16555-641	2	50	0
	MS20074-04-06	3	8	0
	MS21042L5	1	345	0
	MS35426-29	1	3	0
	NAS1149D0463K	3	92	0
	NAS1149D0563J	1	1,218	0
	NAS6605-22	1	6	0
	RB T103347-101-103	1	1	0
	RB T103347-101-115	1	2	0
	RB T103347-101-117	1	4	0
Part Specifications				
Specifications could not be found.				

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REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		REDRAWN IN SOLIDWORKS FROM TATTERED DRAWING. -115 CH'D LIMIT DIM WAS Ø.1875-.1870 IS .1875-.1880. -117 CH'D DIM WAS 4X R.04 IS 4X R.13. -127 CH'D DIM WAS 2X R.06 IS 2X R.13.	6/16/2014	DPD	RJC
2	15-0197	-103 ADDED DIM (.5.25). -115 ADDED ENGRAVE T/N, S/N, MADE IN USA NOTE.	8/5/2015	RJC	JAG



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WITHOUT NOTICE
WORK ORDER
NO. 201529 MJS
19-10-07

NOTE:
REF. BELL T/N: T103347 REV A.



CENTERING, PILOTS CYCLIC STICK

ASSY QTY	ASSY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
X	-103		-103	1	SUPPORT ASSEMBLY			2
			-115	1	BASE	6061		3
			-117	1	CLAMP	6061		4
1			-119		BASE	6061		5
1			-121		ARM	6061		6
1			-123		ARM	6061		7
1			-125		ARM	6061		8
1			-127		HEAD	6061		9
		B/O	-129	1	NUT	STEEL	5/16-24 SPENCER #MS21042L5	1
		B/O	-131	1	WASHER	STEEL	Ø5/16 AIRCRAFT HARDWARE #AN960PD516	1
		B/O	-133	3	WASHER	STEEL	Ø1/4 AIRCRAFT HARDWARE #AN960PD416	1
		B/O	-135	3	BOLT	STEEL	1/4-20 AIRCRAFT HARDWARE #MS20074-04-06	1
		B/O	-137	2	DOWEL PIN	STEEL	Ø3/16 X 7/8 AIRCRAFT HARDWARE #MS16555-441	1
		B/O	-139	1	WING NUT	STEEL	5/16-24 AIRCRAFT HARDWARE #MS35426-29	1
		B/O	-141	1	BOLT	STEEL	5/16-24 AIRCRAFT HARDWARE #NAS6405-22	1
		B/O	-143	1	BUSHING	BRONZE	Ø3/8 O.D. AIRCRAFT HARDWARE #23-006C00-22-16	1
		B/O	-145	2	BUSHING	BRONZE	Ø3/8 O.D. AIRCRAFT HARDWARE #23-006C16-22-15	1
		B/O	-147	1	EYE BOLT	STEEL	5/16-24 AIRCRAFT HARDWARE #AN44-6	1
		B/O	-149	1	DOWEL PIN	STEEL	Ø1/4 X 1-1/2 AIRCRAFT HARDWARE #AN122721	1
ASSY -103								

SHEET 1 OF 9

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		DEPARTMENT/PROCESS		MRB (QS1042)	
Date: _____		Sequence #: _____		QTY Affected: _____			
Description Work Order Deviation							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐		Completed By _____					
Lead hand / Supervisor _____							
QC / QA Coordinator _____							